

Date: Wednesday, 3/21/2007 3:41:02 PM
 User: Kim Johnston

Process Sheet

| | |
|--|------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : END CAP |
| Job Number : 31408 | |
| Estimate Number : 11674 | |
| P.O. Number : N/A | Part Number : D28501 |
| This Issue : 3/21/2007 S.O. No. : N/A | Drawing Number : D2850 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A | Drawing Revision : A |
| Previous Run : 29848 | Material : N/A |
| | Due Date : 4/20/2007 |
| Written By : _____ | Qty: 20 Um: Each |
| Checked & Approved By : <u>07.03.22</u> | |
| Comment : Est. B 98.12.07 Changed folio DM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B2500X01500 | 6061-T6 Bar 2.5" x 1.5" |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.3368 f(s)/Unit Total: 6.7368 f(s)



6061-T6 Bar 2.5" x 1.5"

6061-T6 2.5" X 1.5"

Batch M1007407/03/2320

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: Cut blanks: 3.8"

07/03/2320

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per Folio D2850-1

Deburr and Tumble

SD 07.03.25

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 07.03.25

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

07/03/2620

| | | |
|-----|-------------|-----------------------|
| 6.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/26 (20)SD

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/03/27

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 3:41:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 31408

Part Number: D28501

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 03/21/07
03/21/07 (30)

Job Completion



Handwritten: U 03-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | | |
|---|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 31408 |
| Description: High Float Step End Bracket | | Part Number: D2850-1 |
| Inspection Dwg: D2850 Rev: A | | Page 1 of 1 |

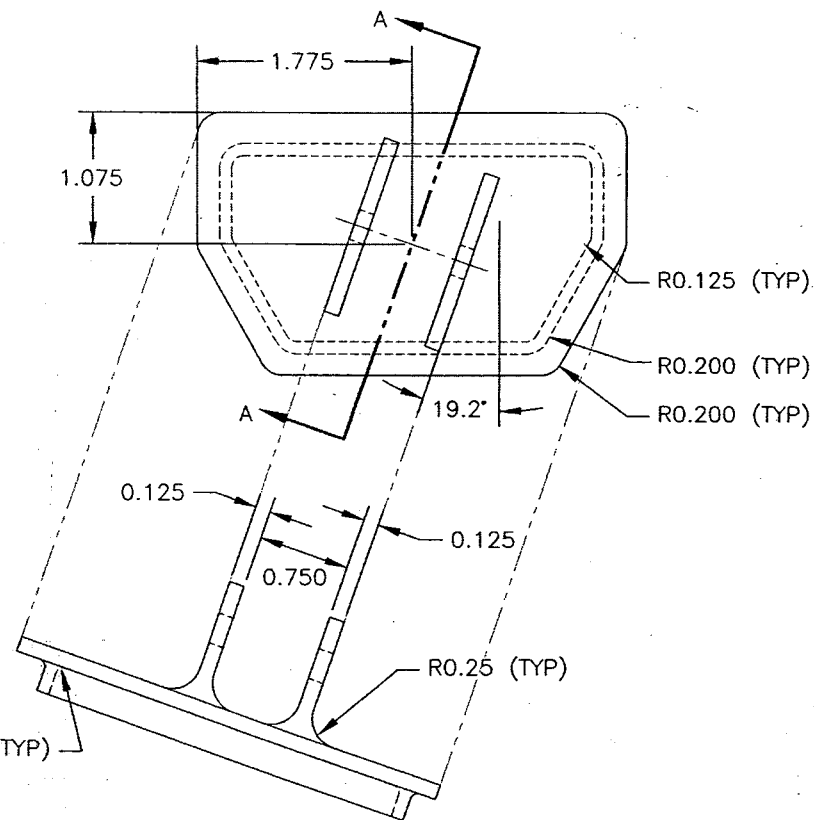
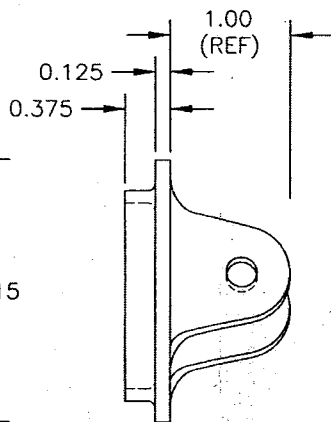
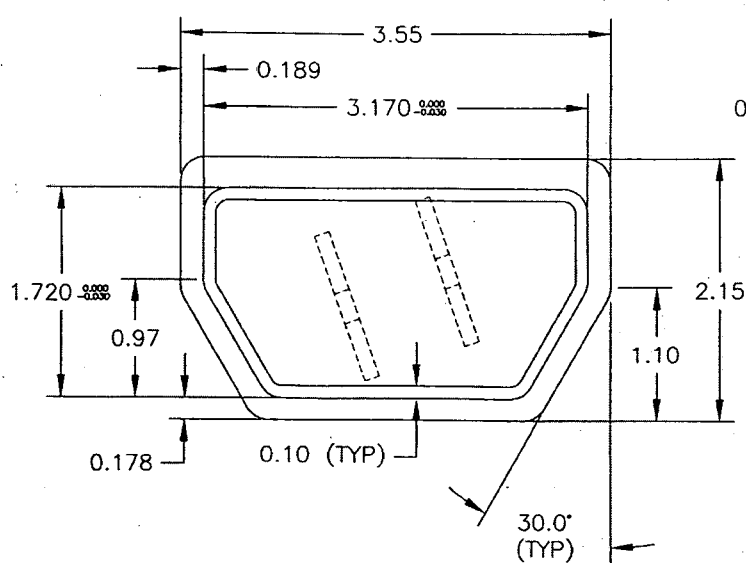
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.720 | +0.000/-0.030 | 1.716 | / | | | |
| 0.178 | +/-0.010 | .176 | / | | | |
| 0.10 | +/-0.030 | .096 | / | | | |
| 30.0° | +/-0.5° | 30° | / | | | |
| 2.15 | +/-0.030 | 2.153 | / | | | |
| 0.375 | +/-0.010 | .373 | / | | | |
| 0.125 | +/-0.010 | .121 | / | | | |
| 1.00 | +/-0.030 | 1.010 | / | | | |
| R0.125 | +/-0.010 | R.125 | / | | | |
| 19.2° | +/-0.5° | 19° | / | | | |
| 0.125 | +/-0.010 | | | | | |
| 0.750 | +/-0.010 | .749 | / | | | |
| 0.600 | +/-0.010 | .607 | / | | | |
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|------------------------|-----------------------------------|----------------------------|-----|
| Measured by: SD | Audited by: J. [Signature] | Prototype Approval: | N/A |
| Date: 07.03.24 | Date: 07/03/24 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|--------------------|-------------|
| A | 06.06.05 | New Issue | KJ/JLM [Signature] | [Signature] |



D2850-1 (SHOWN)
D2850-2 (OPPOSITE)

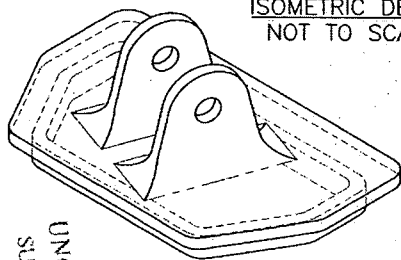
MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

FINISH: NONE

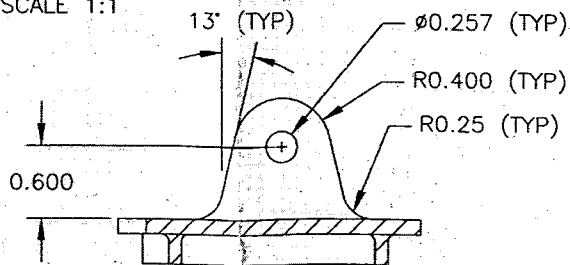
BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

ISOMETRIC DETAIL
NOT TO SCALE



SECTION A-A
SCALE 1:1



RELEASED
95.11.25 82

| | | | |
|---------|----------|--|-----------------------------|
| A | 98.11.10 | NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B | |
| DESIGN | CP | DRAWN BY | CP |
| CHECKED | KE | APPROVED | # |
| DATE | 98.11.10 | DRAWING NO. | D2850 |
| | | TITLE | HIGH FLOAT STEP END BRACKET |
| | | REV. A | SHEET 1 OF 1 |
| | | SCALE | 1:1 |

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NO. 31408
WORK ORDER
31408
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHO COPY